Work Orde Wednesday, Marc										A A A A A A A A A A A A A A A A A A A	Page 1
Revision ID:	D3442-3 Shim	,		Accept					Setup Sta		
Start Date: Required Date: 1 Reference:	3/2/2011 3/8/2011	Start Qty: 4.00 Req'd Qty: 4.00			Cust Ite Custome						
Approvals:	Process Pl	an:	Date: //-03-2	Tooling: SPC (Y/N):		Date:			Run Sta Sto		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool II	D Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3442	Rev	vision Nbr									<u> </u>
Waterjet FLOW CNC Waterjet	t .	FLOW WATER JET Memo 1-Cut as p Deburr if	er Dwg D3442 □Dwg Rev necessary	0.00 :O.00 :□Prog Rev:_	₫			<u>B</u> 11	-3-3	9)
110 QC QC Quality Control		QC2- Inspect parts off	machine FAI/FAIB	0.00				Bu-	3-3		
Quality Control											·

120 QC

QC8- Inspect parts - second check

Memo

Quality Control

Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** Chief Eng / Prod Mgr DATE STEP PROCEDURE CHANGE By Date Qty QC Inspector Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: ________ Disposition: ________ QA: N/C Closed: _______ Date: _______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section E	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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							i	
VOTE: D	ate & initial a	III entries			•	-		

Work Order ID 66912

Wednesday, March 02, 2011 2:30:44 PM



Page 2

Item ID:

D3442-3

Accept



Setup Start

Stop



Revision ID:

Item Name:

Start Date:

Shim

3/2/2011

Start Qty: 4.00 **Req'd Qty:** 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Reject

Qty

Run

Required Date: 3/8/2011

QC:

Date:_____

SPC (Y/N):

Date:

Tool ID

Code

Tool # Plan

Stop

Start

Sequence ID/

Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

0.00

Set Up/

Run Hours

Accept

Qty

Reject Insp. Number Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

Memo

0.00

*****STOCK IN BASKET CELL*****

0.00

M/03/947) mr (1-03-53

Dart	Aeros	pace	Ltd
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W/O:			WC	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						,				
Part No	:	PAR #:	Fault Cate	gory:	NCF	R: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Dispositio	n:	QA:	N/C CId	sed:		Date:	
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section B			Cian 0		ation	Approval	Approval
	O.L.	Section A	Initial Action Description Chief Eng Chief Eng			Sign & Date	Section C		Chief Eng	QC Inspector
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Picklist Print

Wednesday, March 02, 2011 2:30:50 PM

Work Order ID: 66912

Parent Item: D3442-3

Parent Item Name: Shim

Start Date: 3/2/2011

Required Date: 3/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A□05.09.02□New issue□KJ/JLM□

IPP B 07.07.23 waterjet EC

verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	47.2896	0.025	0.105263	•	5	
										HB (1	-3-3		

304/316 .032 Sheet

<u>ocation</u>	Loc Oty	Loc Code	(a
MAT20	47.2896		(~)
109023	16.2896		
109057	31		15067

Page 1

Dart Aerospace i	Ltd	
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	-								
W/O:			W	ORK ORDER CHANG	SES				
DATE	STEP	PRC	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						<u> </u>			
Part No	!	PAR #:	Fault Cate	gory:	NCR: Ye	s No I	DQA:	_ Date: _	
	R	esolution:	Dispositio	n:	QA: N/C	Closed:		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORM	ANCE (NO	R)			
DATE	STEP	Description of NC			ction B	Ve	rification	Approval	Approvai
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		Section C	Chief Eng	QC Inspector
			,						
						4	ş- -		

D3065-5DART AEROS	PACE LTD	Work Order:	116912
	. •		
Description: Shim		Part Number:	D3442-3
Inspection Dwg: D3442	Rev: A		Page 1 of 1

	FIR	ST ARTICLE I	NSPECT	ON CH	ECKLIST		
		X First Art	icle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		nments
1.750	+/-0.010	1.799	¥		V BUZ		
0.750	+/-0.010	,750	2		V		
0.750	+/-0.010	751	5	_	V		
1.625	+/-0.010	1.625	~		V		
							
				•	******		
							
				,			
Measured by:	B	Audited by:	<u></u>		Prototype	Approval:	N/A
Date:	11-3-3	Date:	1103/0	3		Date:	N/A
Rev Date	Change					Revised,by	Approved

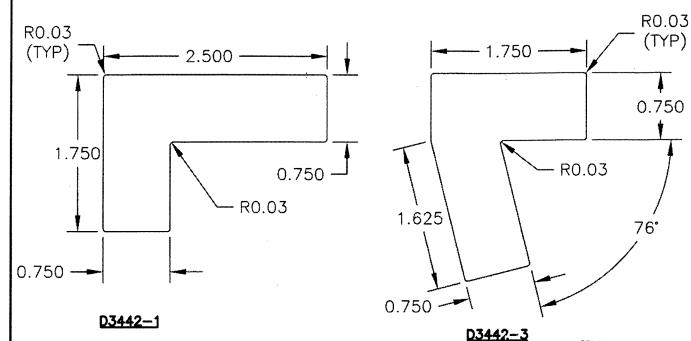
Rev	Date	Change	Revised,by	Approved
Α	08.02.28	New Issue	KJ/DD	X

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-	
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA	.:	_ Date: _	
	R	esolution:	Disposition	n:	_ QA: N/C Cld	sed:		Date:	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verifica	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sectio	on C	Chief Eng	QC Inspector
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DESIG	и РН	DRAWN BY PH	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA					
CHECH	(ED , fi	APPROVED I	DRAWING NO. REV.					
	#	世	D3442 SHEET 1 OF					
DATE			TITLE SCAL					
05.0	6.03		SHIM 1:					
Α		05.06.03	NEW ISSUE					



D3442-1/-3 SHIM

MATERIAL:

AISI 304/316 SS SHEET 21 GAUGE (0.034 THICK)

(REF DART SPEC M304S21GA)

2) FINISH:

NONE

3) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COP

RETURN TO

ENGINEERING

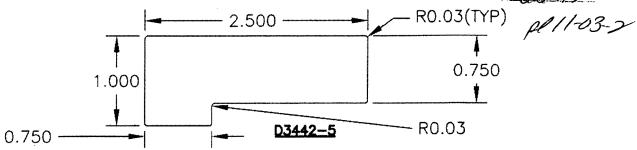
UNCONTROLLED (*

SUBJECT TO AMENDME!

WITHOUT NOTICE

WORK ORDER

NO. 06212



D3442-5 SHIM

1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK)

(REF DART SPEC M304S16GA)

2) FINISH:

3)

NONE

ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED RELEASED

05.08.19

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Dart Aerospace Ltd

W/O:	•		WO	RK ORDER CHANG	BES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							!		
	,								
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	QA: N/C C	QA: N/C Closed:				
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NC	R)			
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